QC1- Inspect dimensions to dimension sheet

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Memo

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Quality Control

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(4)		DQA:	Date:	•
ICR· Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Ciosea.	Date		
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Part N	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
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Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misrea Offset Out of	ion Incomplete tions Incomplete/ enance eled	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
	Wave/Twist in Tube				Folio		Outside Dimensions							

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Quality Control

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	Turning Sequence Finish								Out of S	Sequence				
	Wave/Twist in Tube Folio								Outside	Dimensions				

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Work Order ID 92625 *92625* Page 3 Tuesday, November 06, 2012 10:03:00 AM Item ID: D212-664-207TRN Accept *N900040100* Setup Start **Revision ID:** Crosstube Turning Detail Item Name: Start Date: Start Oty: 1.00 11/6/2012 Cust Item ID: **Required Date:** 11/23/2012 Reg'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: Tooling: **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 145 0.00 Mo 12/11/12 *145* Crosstubes 0.00 Memo Crosstubes GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY 150 0.00 *150* HandFXtube 0.00 Memo 12/11/14 Hand Finishing Crosstubes 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ACID ETCH X-TUBE INSIDE AND OUT, USE RED SCOTCH BRITE 160 QC5- Inspect part completeness to step on W/O 0.00 *160* 0.00 Memo Quality Control

											DQA:	Date:	
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Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Work Orde Tuesday, Novem				*926	325*			Page 4
Item ID: Revision ID: Item Name:	D212-664-20			Accept	*N900040	1100*	Setup Sta	art *NS1* op *NS2*
Start Date: Required Date: Reference:	11/6/2012 11/23/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:			
Approvals:	Process Plan		Date:	Tooling: SPC (Y/N):	Date:	·	Run Sta	*NR1* *NR2*
Sequence ID/ Work Center II 170	D	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Acce Code Qty	ept Reject Qty	Reject Insp. Number Stamp
170 Packaging Packaging		Packaging Memo Identify and Location:	stock in kanban rack	0.00		MO	12/	11/14
¹⁸⁰ *18∩*		QC21- Final Inspection -	Work Order Release	0.00			10	alialida
QC Quality Control		Memo		0.00				

13-13-13/11

NCR:	Yes	/ No				WORK ORDER NON-C	O	VFORM	MANCE / UPI	DATE					į i
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	Cuffs					Contamination		Mainte	enance			Part Moved			
	Heat Treat			1	Countersink	Mislabeled			Positioned Wrong						
	Inspection Strip in Tube			Cut Too Short	Misread				Power Loss/	Surge		Other			
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	Turning Sequence					Finish		Out of	Out of Sequence						

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

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Picklist Print

Tuesday, November 06, 2012 10:02:59 AM

Work Order ID:

92625

Parent Item:

D212-664-207TRN

Parent Item Name:

Crosstube Turning Detail

Start Date: 11/6/2012

Required Date: 11/23/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 08-03-06 DD verified by:ec

IPP Rev B 08.04.02 Removed polish EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6008-132		Manufactured	No			110	Each	0.0000	1	1			
Crosstube extrusion		Manufactured	NO			110	Each	0.0000	1	1		•	

69799

12/11/05 mm.C

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	Cracks				Broken/Damaged			on Incomplete		Part Incorre	⊢	Weld		
		/Crimped			Burrs			ions Incomplete/Unclear		Part Lost/Mi	issing	Wrong Stock Pulled		
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	Ripples i				Drill Holes	Off	set							
	Torque \	Naves in I	Extrusion	ı	Drawing	Out of Calibration								
	Turning	Sequence	i		Finish	Out of Sequence								
	Wave/T	wist in Tul	be		Folio Outside Dimensions									

Date:

DQA:

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ltem	Qty -247	Qty -247B	Part Number	Description
1	X		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		Х	D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)
3	1	1	D6008-132	CROSSTUBE
4	2	2	D2940-1	SUPPORT
_5 .	4	4	D3595-063-530	RUBBER CUSHION
6	2	2	D3660-1	CUFF
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

6

GENERAL NOTES:

D

- 1) MATERIAL. MANUFACTURED FROM D6008-132
- FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4 2
 PAINT OUTSIDE PER DART QSI 005 4.2
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX IDENTIFICATION. SCRIBE DART PART NUMBER 'D212-664-XXX' AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT D212-664-247 = 36.6 lbs (PER IIN-D212-664)
- D212-664-247B = 36 6 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
 WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON 0.D., EXCEPTUP TO 10% IS ALLOWED IN AREA NOTED.

 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
 12) INSTALL D2940-1 SUPPORT USING 0.03° TO 0.06° THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
- INSTALL D2940-1 SUPPORT USING 0.03* TO 0.05* THICK LAYER OF MACNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
 INSTALL MS21920-28 CLAMPS (OR 3.0) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
- SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS
- 17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT



2

DEO ATTACHED

550# 11-614 11.07.28 UNDER REVIEW

В			OTES/PART LIST; UPDATE TO DS; ADD -247B (ZN C4-2, D5-2)	RF	09.09.30	
Α	NEW IS	SSUE		CP	07.07.07	
REV.			DESCRIPTION	BY	DATE	
DESIGN		a)	DART AEROSP	ACE	LTD	
DRAWN		RF	HAWKESBURY, ONTAR			
CHECKE	D	P	DRAWING NO.		REV. B	
MFG. AF	PR.	<i>P</i>	D212-664-247		SHEET 1 OF 4	
APPRO\	/ED	10	TITLE		SCALE	
DE APPI	٦.	-	CROSSTUBE (205/212 LOW	NTS:		
DATE	09.0	9.30	COPYRIGHT © 2007 BY DART A THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLE NOT TO BE USED FOR ANY PURPLES OR COMBANY AS YEARTER PERMISSION FROM DART AS	OON THE EXP	RESS CONDITION THAT IT IS OTHER PERSON WITHOUT	

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NCR:		Yes	/	No

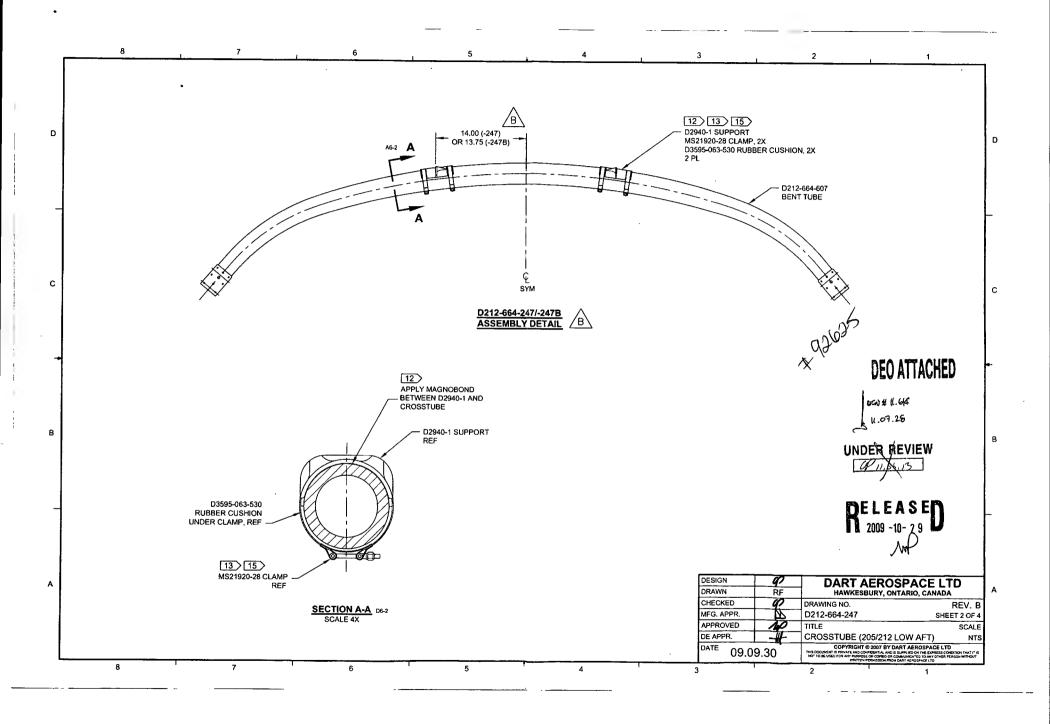
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							Rework			Skid-tube Crosstube			Water Jet	Engineering
Part I	۱٥٠ ِ						Scrap			Machining Small Fab	\dashv		d. Eng. Coor.	Quality Other
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		Cracks				<u> </u>	Broken/Damaged	_	1	ion Incomplete	Part In		-	Weld
		Crushed/0	Crimped.				Burrs	\vdash	ł	tions Incomplete/Unclear	Part Lo			Wrong Stock Pulled
		Cuffs				_	Contamination	<u> </u>	1	enance	Part Moved			
	L.,	Heat Trea				L	Countersink		Mislabe		Positio			
	Ŀ		ection Strip in Tube Cut Too Short									Other		
							Drill Holes	Offset						
		Torque W			n	<u> </u>	Drawing	L	-	Calibration				
	Turning Sequence Finish								Out of	Sequence				

Outside Dimensions

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Wave/Twist in Tube

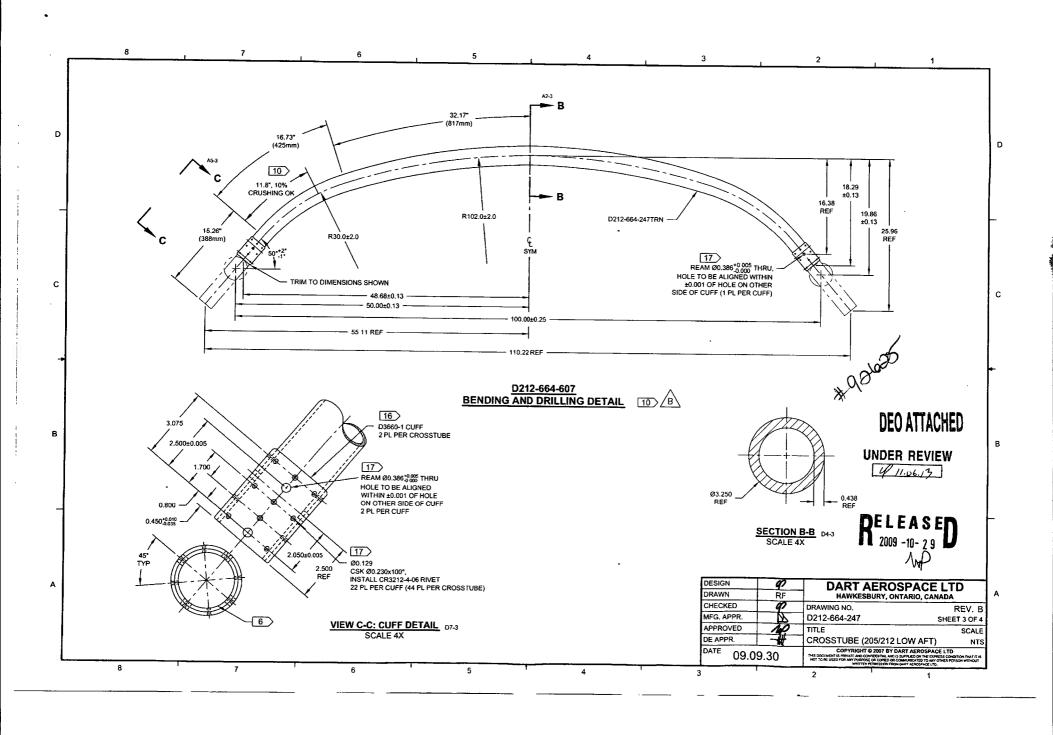
Folio



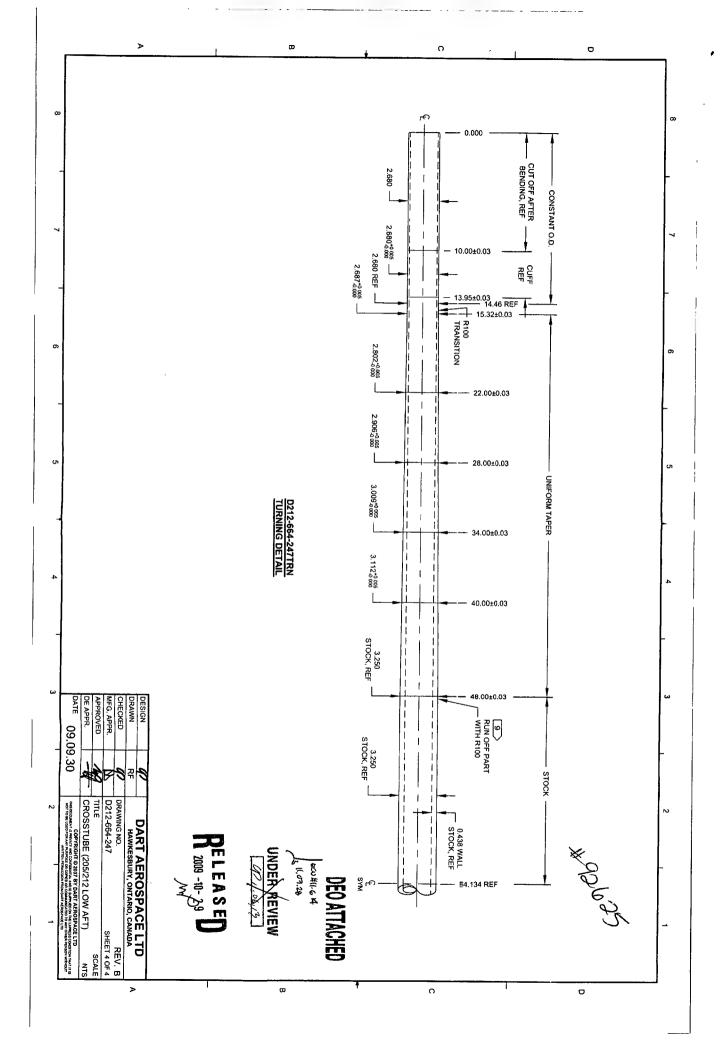
NCR: Y	es / No				WORK ORDER NON-C	CONF	OKIN	HANCE / UPDATE		QA Closed:	Date	e:
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Part N	1				Rework Scrap						Engineering Quality	
NCR N	No				Use-as-is Work Order Update	T		~ 	nishing nposite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initi	ial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
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DQA: Date:

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DRAWING NO.	TITLE	DEV D	DART AFROS	240-1	·		
D212-664-247	1	REV. B	DART AEROS	PACE LTD D.E.O. N	10.	SHEET NO.	SCALE
	CROSSTUBE ASS'Y (20	5 LOW AFT)	ENGINEERIN	G ORDER D212-6	64-247-B-1	SHEET 1 OF 1	NTS
DRAWN 9	CHECKED	A>5	MFG. APPR.	APPROVED	SWD	DE APPR.	
DATE 11.07	.15 DATE //.	2777					
		1.60	DATE .07	·2 DATE	11/07/2)	DATE (07.2)	

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

ltem	Qty -247	Qty -247B	Part Number	Description
9	A/R	· A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	A/R	1	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2940-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



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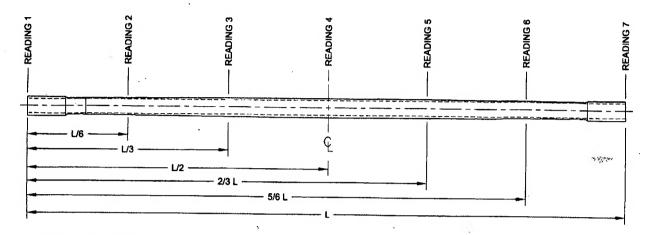
DART AEROSPACE LTD	Work Order:	92625
Description: Crosstube Assembly (205/212 Low Aft)	Part Number:	D212-664-247
Inspection Dwg: D212-664-247 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	spection Sheet wing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	0.438	+/-0.010	.438	-		vern	CNC -08
	2.680	+0.005/-0.000	2.681			1	2000
	2.680	+0.005/-0.000	2.683				
İ	2.687	+0.005/-0.000	2.690	7			
-	2.802	+0.005/-0.000	2.807				
	2.906	+0.005/-0.000	2.910			<u> </u>	
EA	3.009	+0.005/-0.000	3.012	-			
SIDE	3.112	+0.005/-0.000	3.115	_			
0,	3.250	+0.005/-0.000	3.250			V	
	0.438	+/-0.010	.438			VEIN	CNC-06
-	2.680	+0.005/-0.000	2.663	/		1	0000
	2.680	+0.005/-0.000	2685	/			
	2.687	+0.005/-0.000	2692				
	2.802	+0.005/-0.000	2.807				
a	2.906	+0.005/-0.000	2.911	_			
	3.009	+0.005/-0.000	3.013				
SIDE	3.112	+0.005/-0.000	3-116				
	3.250	+0.005/-0.000	3.250	(V	
	400.000		12.0				,
	128.268	+/-0.030	128.26			tapp	LG-22

DART AEROSPACE LTD	Work Order:	92625
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WALL THICKNESS MEASUREMENT



	WALL	THICKNESS	Deviation			
Location	w1	w2	w3	w4	Δw (max-min)	TOLERANCE
READING 1 L= 0"	.164	.144	.158	.174	-030	
READING 2	-195	.164	.160	177	*035	
READING 3	.333	-364	.297	.317	-636	•
READING 4	.441	.447	-450	. 438	1012	0.054"
READING 5	-326	,290	,295	.330	.040	
READING 6	,195	-158	./49	.189	,046	
READING 7 L= CUFF	.172	160	. 151	.166	.021	

Calibration Result

Actual Block Thickness: \$100.750

Sitescan 250 Measured Thickness: . 100 .750

Measured by: App. L,		MM. C. Audited by: JU	Preliminary Approval:	
	Date:	12/11/06 Date: 12-11-8	Date:	
Rev	Date	Change	Revised by	Approved
Α	08.11.07	New Issue (P/O D212-664-207)	KJ/EC	Approved
В	10.04.01	Dwg Rev updated	KJ	
С	10.08.03	Dimension 128.268 was 128.27	KJ 10	
D	12.06.04	Wall thickness form added	KJ d	M

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